

Work Order ID 127215

127215

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Monday, December 15, 2014 11:47:39 AM

Item ID: D4435-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: T/R Bellcrank Cover Assembly
 Start Date: 12/15/2014 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 12/15/2014 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-12-15 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4435	B

100		0.00							
100									
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg								

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

P70

12x DAS 28 9-89 DEC 16 2014

12 DAS 38 9-89

JAN 05 2015

DQA: 15/2/23

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: 8/10/10 Date: 15/2/10Work Order update only ☐

Work Order: <u>127215</u>	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. <u>D4435-045</u>	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	
NCR No. <u>15-4583</u>	Scrap ☒	Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design				1 part was scrap at the assembly had to removed a rivet and hole in large on the D4435-5 Tooling. R.C. Training	S 15/01/27 Q22012	Scrap a destroy part and replace it D4435-5 B126471 <u>B10.38</u>	M.A. 5/01/2015	DAS 30 9-89	S 15/01/27
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator	15/01/25	100	1						
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☒ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Pressure/Forced
☐ Marks/Chatter	☒ Drill Holes	☐ Off-set	☐ Set-up
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
120									
Powdercoat	Memo <u>11/27892</u>	0.00							
Powder Coating	*** MASK NUT PLATE HOLES ***								
	START TIME: <u>10.15.</u>								
	OVEN TEMPERATURE: <u>320</u>								
	FINISH TIME: <u>10.45.</u>								
130	QC3- Inspect Part Finish	0.00							DAS 38 9-89
130									
QC	Memo	0.00							
Quality Control									JAN 07 2015
140	Identify as per dwg & Stock Location: <u>S620</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging									JAN 08 2015

60-4
98
DAS

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21 - Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

ML5 1501-09

Signature 151-8

Picklist Print

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Work Order ID: 127215

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Parent Item: D4435-045

D4435-045

Parent Item Name: T/R Bellcrank Cover Assembly

Start Date: 12/15/2014

Required Date: 12/15/2014

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevB 11.12.22 per PA2 EC verified by:JLM IPP RevC
12.01.23 per REVA DD verified by:EC IPP REV:D 12.03.06
AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4435-5 *D4435-5* Mount Bracket		Manufactured	No			100	Each	0.0000	1	13 126471		DAS 28 9-89	DEC 15 2014
D4435-7 *D4435-7* Bracket		Manufactured	No			100	Each	12.0000	1	12			
					<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>				
					ST619			12					
					126139			12		12			
MS20426AD3-2 *MS20426AD3-2* Rivet		Purchased	No			100	Each	18,153.00	4	48		DAS 28 9-89	
					<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>				
					Mezz			18153		128754			
					1173			8873					
					13276			9280					
MS20470AD4-3 *MS20470AD4-3* Rivet - Universal Head		Purchased	No			100	Each	2,451.000	4	48		DAS 28 9-89	
					<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>				
					GA			1187		48			
					2193			1187					
					ST310			1264					
					2193			1264					

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Parent Item Name: T/R Bellcrank Cover Assembly

Start Date: 12/15/2014

Required Date: 12/15/2014

Start Qty: 12.00

Required Qty: 12.00

MS21059L3

Purchased

No

100

Each

239.0000

1

12

MS21059L3

Nut Plate

DAS
28
9-89

DEC 16 2014

Location

Loc Qty

Loc Code

CA

16

M129682

16

GA

164

M130823

164

ST303

59

M130823

59

MS21062L3

Purchased

No

100

Each

51.0000

1

12

MS21062L3

Nut Plate

DAS
28
9-89

Location

Loc Qty

Loc Code

ST302

51

m126275

51